








Work Order ID 48146




Friday, June 26, 2009 10:45:08 AM



Page 1

Item ID: D3117-3 Accept  Setup Start 
Revision ID: C Stop 
Item Name: Seal Filler
Start Date: 7/15/2009 Start Qty: 500.00  Cust Item ID:
Required Date: 8/3/2009 Req'd Qty: 500.00  Customer:
Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3117	Rev C								
100	PURCHASING	0.00							✓
									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 8843 <input type="checkbox"/> D3117-3 Seal as per Dwg D3117 <input type="checkbox"/> Possible Supplier: VIP Rubber Replace Premier P/N: B45-43000-03 Material release note required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
									
Packaging	Memo	0.00							
Packaging	Ensure Material Release Note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
									
QC	Memo	0.00							
Quality Control	Check dims to dwg and certification attached								

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Item ID: D3117-3

Accept



Setup Start



Revision ID: C

Stop



Item Name: Seal Filler

Start Date: 7/15/2009 Start Qty: 500.00



Cust Item ID:

Required Date: 8/3/2009 Req'd Qty: 500.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: 404

0.00



Packaging

Memo

0.00

Packaging

9/7/16 500/480

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/2009 [Signature]U 56-07.17

Picklist Print

Page 1

Friday, June 26, 2009 10:45:08 AM

Work Order ID: 48146



Parent Item: D3117-3RevC



Parent Item Name: Seal Filler

Start Date: 7/15/2009

Required Date: 8/3/2009

Comments:

Start Qty: 500.00

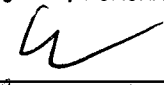
Required Qty: 500.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3117-3PRevC		Purchased	No			110	f	0.0000	500.0000			✓

Seal Filler

Date: Friday, 22/05/2009 2:26:36 PM
 User: Chantal Lavoie

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	SEAL
Job Number :	48146		
Estimate Number :	10736		
P.O. Number :		Part Number :	D31173
This Issue :	22/05/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D3117 REV C
First Issue :	//	Project Number :	N/A
Previous Run :	47475	Drawing Revision :	C
Written By :		Material :	
Checked & Approved By :	<u>CLO9/05/22</u>	Due Date :	17/06/2009
Comment :	Est. A 03.01.22 New issue KJ/RF		

Qty: 500 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 8843

D3117-3 Seal as per Dwg D3117

Possible Supplier: VIP RubberReplace Premier P/N: B45-43000-03

Material release note required

CLO9/05/22

(500)

2.0	D31173P	Seal Filler
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 500.0000 Each(s)
 SEAL FILLER

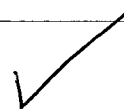
3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached



4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

Inspect Level 6 Check dims to dwg and certification attached.

S0514/15 x500ft

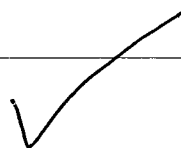
5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 2:26:36 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAL

Job Number: 48146

Part Number: D31173

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

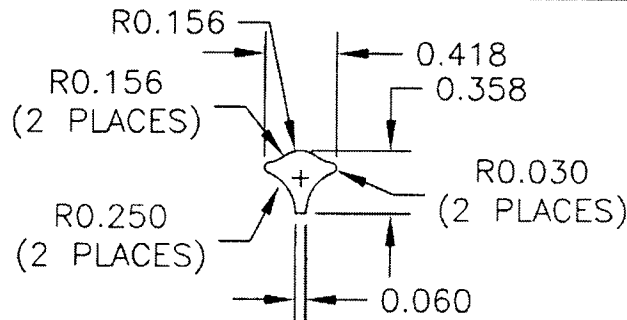
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

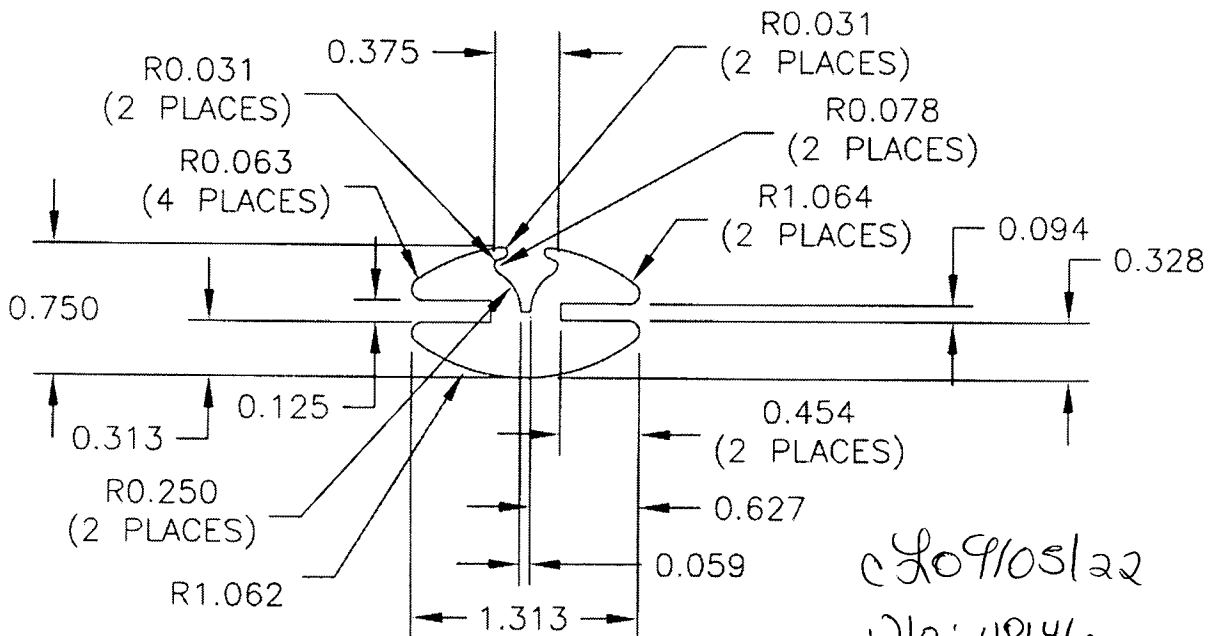
NOTE: Date & initial all entries

DART

DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3117	REV. C SHEET 1 OF 1
DATE 05.10.03		TITLE SEAL	SCALE 1:1
A	02.04.15	NEW ISSUE	
B	04.10.18	UPDATES NOTES	
C	05.10.03	50 DUROMETER WAS 60 DUROMETER	

**RELEASED**05.10.03 *[Signature]***D3117-3-XXXX SEAL FILLER**

REPLACES PREMIER P/N B45-43000-03

c 209/05/22
w/o: 48146**D3117-1-XXXX SEAL RETAINER**

REPLACES PREMIER P/N B45-43000-01

NOTES

- 1) -XXXX = LENGTH IN INCHES (EG. 10" LONG = -0100, 87.5" LONG = -0875)
- 2) MATERIAL: BLACK RUBBER 50 DUROMETER (HARDNESS) NEOPRENE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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Vip Rubber Company

EXTRUDED AND MOLDED RUBBER • EXTRUDED PLASTIC

540 S. CYPRESS STREET, LA HABRA, CA 90631

(310) 905-3456 • (800) 722-4VIP

Fax: (310) 905-3460

*Blue
order*

3626

CERTIFICATION OF COMPLIANCE

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY ONTARIO, CANADA
K6A1K7 613-632-9577

ITEM NO.

RE-7107-189"-0156

CUSTOMER PO.

P000008843

DATE

6-11-09

SHIPPER NO.

80646

THIS IS TO CERTIFY THAT
THE MATERIAL FURNISHED
ON THIS PURCHASE ORDER
WAS MADE IN STRICT
CONFORMANCE WITH THE
NOTED SPECIFICATION.

PART NO/DESCRIPTION

P/N D3117-1 REV C RETAINER

P/N D3117-3 REV C FILLER

(DWG. #D3117 REV C)

QUANTITY
ORDERED

500 FT

500 FT

CURE DATE

3-2-09

SPECIFICATION

50/NEOPRENE FORMULATED TO MEET THE FLAME
RESISTANCE TEST OF FAR 25.853a LOT #

93559

By

Martin Perez

MARTIN PEREZ
TECHNICAL DIRECTOR

VIP RUBBER COMPANY

05/02/15

DATE SHIPPED

7/9/09

QTY. SHIPPED

500 FT

500 FT


VIP Rubber Company, Inc.

 540 S. Cypress
 La Habra, Ca. 90631

FINAL INSPECTION REPORT

Customer Dart Aerospace Ltd.				Purchase Order # P000008843			
Part Number/Dwg. Number D3117-1 &-3 (Filler & Retainer)				Revision C			
Job # 1299		Lot # 193141		AQL Rubber 4.0 / C=0; Plastic 6.5 / C=0			
Lot Size 500 FT		Sample Size 500 FT					

Dimensions Measured									
Dim.	.418	.750							
Tol. +/-	.051	.063							
Range	0.469	0.813							
	0.367	0.687							
Descr.	Filler	Retainer							
1	.418	.800							
2	.418	.800							
3	.420	.800							
4	.420	.805							
5	.418	.800							
6	.418	.800							
7	.420	.805							
8	.420	.800							
9	.418	.800							
10									
11									
12									
13									
14									
15									
16									
17									
18									
19									
20									

Other Observations (If Required)							
	Required	Tolerance	Actual		Required	Tolerance	Actual
Durometer	50	+/- 5	50	Visual	✓	N/A	ace
Color	Black	N/A	ace		Marking	N/A	N/A

Inspection Notes:					
No. of Observations	12	Qty. Approved	12	Qty. Rejected	0

Inspected By	J.O.	Date	7/9/09
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